



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D3405-043
Job Sheet 190923



Part No: D3405-043

Job Qty: 16 pcs

Part Name: Ground Handling Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 5/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 05.09.01 New issue KJ/JLM IPP B 09.01.28 Rev b dwg EC verified by: DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S186685



Part: D3405-043

Job No: 190923

Serial No/Batch: S186685

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/11/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		5/20/19	0.00	1.44	Waterjet - Flow		<i>02/19/06/03</i>
110	QC 2	16 pcs		5/20/19	0.00	0.00	QC 2 - 1		<i>02/19/06/03</i>
120	QC 8	16 pcs		5/20/19	0.00	0.00	QC8-2		<i>DAS JUN 04 2019 40</i>
130	Small Fab - Brake NC - B4B	16 pcs		5/20/19	0.09	1.16	Small Fab - Brake - 1 - B4B		<i>DAS 30 9-89</i>
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	16 pcs		5/20/19	0.00	0.00	QC5		<i>DAS JUN 10 2019 40</i>
150	Large Fab - Welded Assy-2-B4B	16 pcs		5/20/19	0.00	4.75	Large Fab - 1 - B4B		<i>02</i>
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
160	QC 9	16 pcs		5/20/19	0.00	0.00	QC9		<i>DAS 24 9-89 JUN 12 2019</i>
170	QC 5	16 pcs		5/20/19	0.00	0.00	QC5		<i>DAS 24 9-89 JUN 12 2019</i>
180	Powdercoat - 2 White Gl(S)-B4B	16 pcs		5/20/19	0.00	0.44	Powdercoat2		<i>02/18-8-12 DAS 40 9-89</i>
190	QC 3	16 pcs		5/20/19	0.00	0.00	QC3		<i>JUN 12 2019 40 9-89</i>
200	Packaging 3-1 - Stock - B4B	16 pcs		5/20/19	0.00	0.00	Packaging3-1		<i>57529</i>
210	QC 21 - SA	16 pcs		5/20/19	0.00	0.00	QC21		<i>DAS 21 9-89 JUN 13 2019</i>

Part Op 100 - 1-Cut as per Dwg D3405 Dwg Rev: 6 Prog Rev: 6 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming

140 - (QC5- Inspect part completeness to step on W/O)

150 - Weld as per Dwg D3405 use DT8484 Identify as D3405-043

160 - (QC9- Inspect visual per QSI004- Fusion Welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (White Gloss(Ref 4.3.5.2) per QSI005 4.3-Steel) START TIME: 1045 OVEN TEMPERATURE: 400

FINISH TIME: 11:15

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.4640 sf (.154 ea)	100-Waterjet - Flow - 1	<i>5159397</i>
D3404-1	Ground Handling Wheel Lug	16 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	<i>5169664</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	2	73	0
150-Large Fab - Welded Assy-2- B4B	D3404-1	16	38	0
Part Specifications				
Specifications could not be found.				

Plex 6/3/19 9:23 AM dart.lacelle.linda

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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min